

Date: Tuesday, 03/03/2009 4:12:08 PM
 User: Julie Dawson

Process Sheet

RUSH

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 46248	
Estimate Number : 11000	
P.O. Number :	Part Number : D26021
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D2602 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 45390	Material :
Written By :	Due Date : 24/03/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JLD 09-03-04</u>	
Comment : Est. D 04.02.25 Reformat KJ/RF	
Note: Issue with part number D2602-2	
Est Rev:E Now On Waterjet 07-03-22 JLM	
Est Rev:F RevB as per dwg ECN1059 DD verified by:EC	
Est Rev:G 09-03-02 as per NCR09-027 DD verified by:JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty.: 1.4146 sf(s)/Unit Total : 11.3165 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch 110337 B 9-4-13

2.0

WATER JET

FLOW WATER JET

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2602

*****Same Cutting File for -1 & -2 *****

Dwg Rev: BProg Rev: BB 9-4-13

2-Deburr if necessary

B 9-4-13

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-13**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK09/04/14 (KB)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:12:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 46248

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

SP 09/04/14

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/04/14 (-1) (x8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-04-14 (x8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-14 (x8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST177

09/04/14 (x8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 (x8)

Job Completion



U 09.04.14

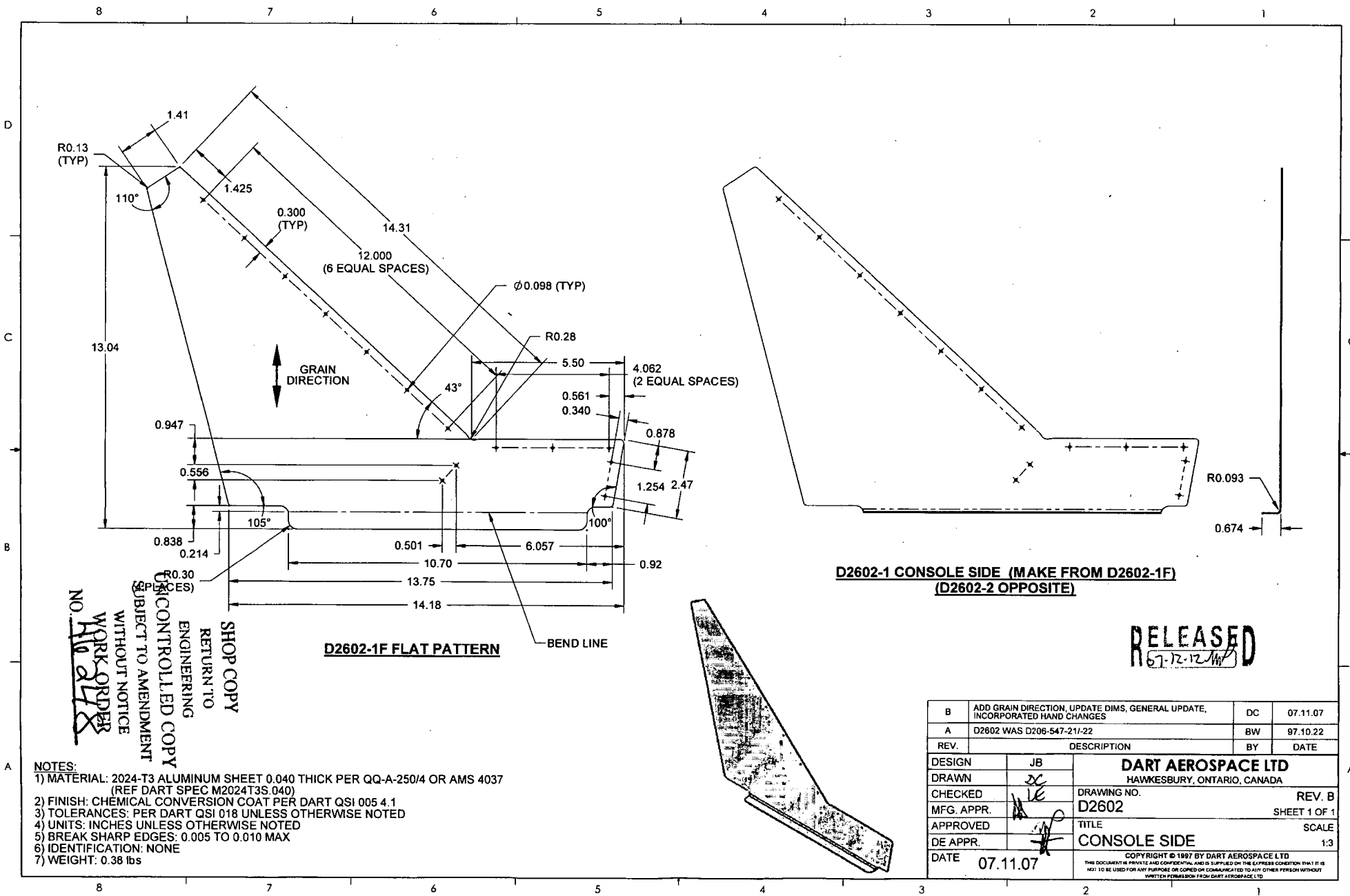
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2602-1F FLAT PATTERN

**D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)**

RELEASED
67-12-12

NO. 110248
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.38 lbs

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2602 WAS D206-547-21/22	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	3C		
CHECKED	LE	DRAWING NO.	REV. I
MFG. APPR.		D2602	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE 1:3	
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	